

Work Order ID 61015

August 4, 2010 8:57:16 AM



Page 1

Item ID: D4151-3

Accept



Setup Start



Revision ID:

Item Name: Upper Hardpoint Plate

Stop



Start Date: 8/04/10 Start Qty: 10.00



Cust Item ID:

Required Date: 8/11/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10-8-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4151

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4151

Prog Rev: *B*

Dwg Rev: *B*

304 .125

Deburr as required

B 10-8-9

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-8-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61015

August 4, 2010 8:57:16 AM



Page 2

Item ID:	D4151-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Upper Hardpoint Plate					
Start Date:	8/04/10	Start Qty:	10.00		Cust Item ID:	
Required Date:	8/11/10	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00				(+10)			Pro →
Quality Control									

150	Identify as per dwg & Stock Location: <u>124</u>	0.00							
Packaging	Memo	0.00							10/08/10 sl (100)
Packaging									

160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							10/08/10 [Signature]
Quality Control									

me
10-8-10

W/O: 61015		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/8/09	* 120	Took Qty x1 For QC inspection template	S	10/08/09	x1		S 10/08/09

Part No: D4151-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 4, 2010 8:57:21 AM

Page 1

Work Order ID: 61015



Parent Item: D4151-3



Parent Item Name: Upper Hardpoint Plate


Start Date: 8/04/10

Required Date: 8/11/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	91.2982	0.055	0.578947	7		

B10-8-9

Location

Loc Qty

Loc Code

MAT

91.2982

114488

1.5259

114799

89.7723

114799

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 6105
Description: UPPER HARD POINT PLATE		Part Number: D4151-3
Inspection Dwg: D4151-3 Rev: B		Page 1 of 1

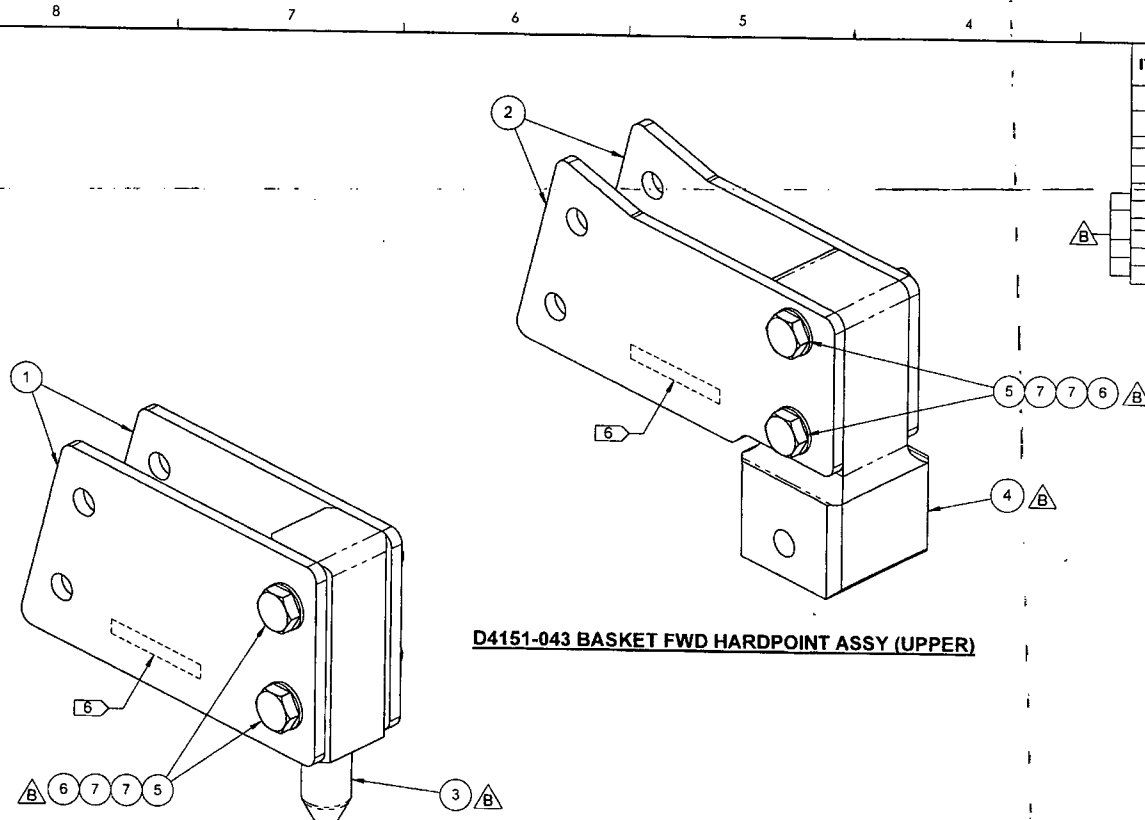
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .191	+ .005 - .001	.193	✓		✓ HB02	
Ø .257	+ .006 - .001	.259	✓		✓	
.375	± .010	.375	✓		✓	
2.53	± .030	2.533	✓		✓	
1.75	± .030	1.758	✓		✓	
1.000	± .010	.999	✓		✓	
.450	± .010	.450	✓		✓	
.150	± .010	.159	✓		✓	
.500	± .010	.503	✓		✓	
1.100	± .010	1.100	✓		✓	
1.250	± .010	1.250	✓		✓	
3.460	± .010	3.460	✓		✓	
3.97	± .030	3.960	✓		✓	
.454	± .010	.457	✓		✓	
1.99	± .030	1.99	✓		✓	
1.000	± .010	1.000	✓		✓	
.125	± .010	.117	✓		✓	

Measured by: JB	Audited by: S	Prototype Approval: N/A
Date: 10-8-9	Date: 10/02/07	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)

D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN3C13A	BOLT
6	2	2	MS21043-3	NUT
7	4	4	NAS1149C0332R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41015
BS10-8-04

RELEASED
2010-07-16

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT:
 - D4151-041 = 0.84 lbs
 - D4151-043 = 1.17 lbs

B	ADDED D4151-5/-7 (SHT 3); D4151-5 WAS D3811-1 (ZN B6-1 & D3-1); D4151-7 WAS D3811-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20615-4M20 (ZN C3-1, D3-1 & B8-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2); REASON: SEE TR-D380-007-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4151	REV. B SHEET 1 OF 3
TITLE BASKET FWD HARDPOINT	SCALE NTS
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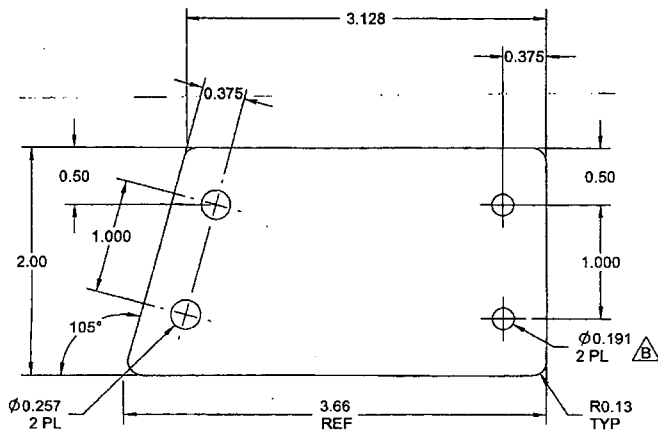
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

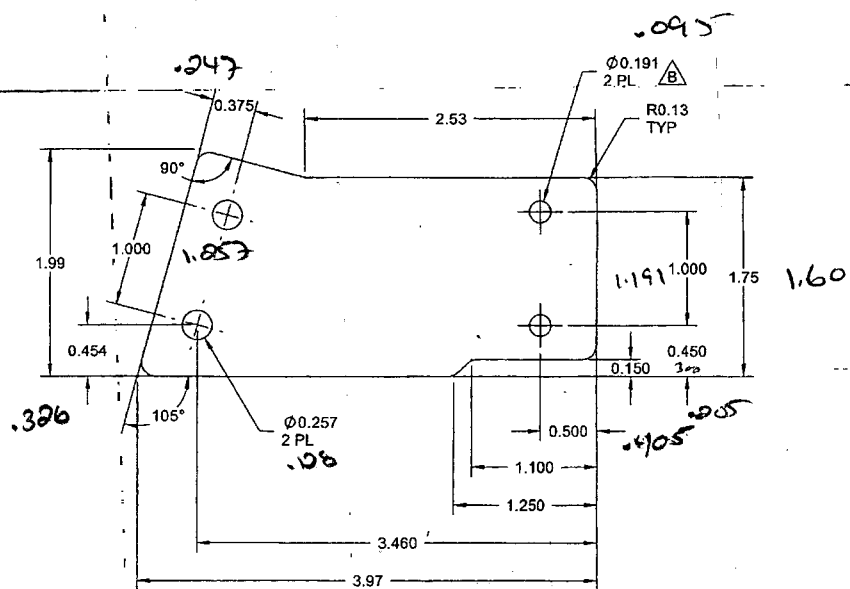
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



0.125
REF

D4151-1 LOWER HARDPOINT PLATE



0.125
REF

D4151-3 UPPER HARDPOINT PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:
 - D4151-1 = 0.24 lbs
 - D4151-3 = 0.23 lbs.

WLO 61015

RELEASED
2010-07-16

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4151	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
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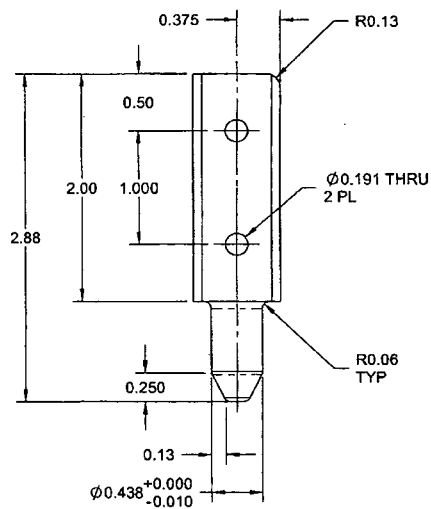
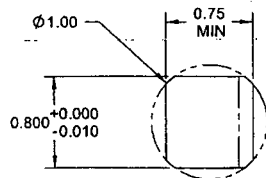
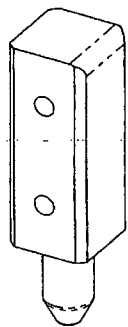
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

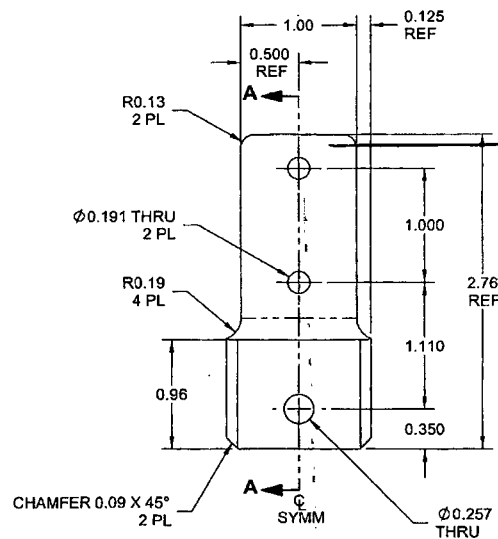
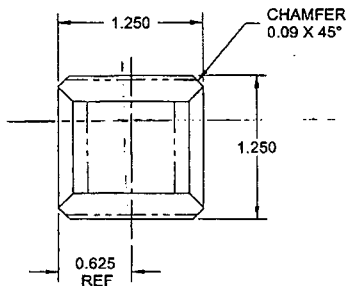
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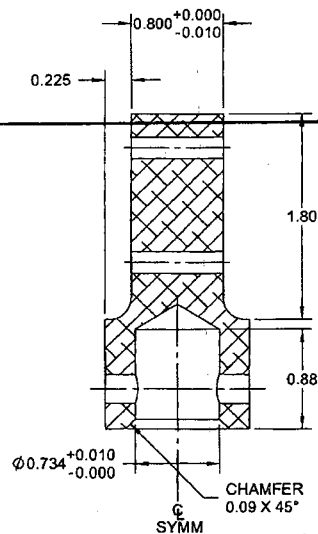
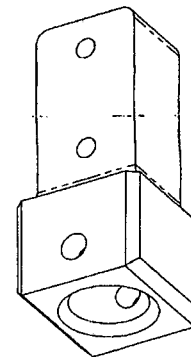
NOTE: Date & initial all entries



D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

NOTES:

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

WLO 6/10/15

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4151	REV. B
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE BASKET FWD HARDPOINT	SCALE
DE APPR.			NTS
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2010-07-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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